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D3913-041
Job Sheet 176464



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/24/18

Job Tracking No:

Due Date: 5/21/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/21/18	0.00	0.00	Start Up Large Fab-5		<i>D.M.L 18/6/18</i>
100	Large Fab	1 pcs		5/21/18	0.00	10.00	Large Fab 1		<i>C.T 18/6/21</i>
110	QC	1 pcs		5/21/18	0.00	0.00	QC9		<i>DY 2018-06-27</i>
120	QC	1 pcs		5/21/18	0.00	0.00	QC5		<i>DY 2018-06-27</i>
125	HandFinish	1 pcs		5/21/18	0.00	0.29	HandFinish2		<i>18-7-18</i>
130	Powdercoat	1 pcs		5/21/18	0.00	0.93	Powdercoat2		<i>18-7-18</i>
135	Packaging	1 pcs		5/21/18	0.00	0.00	Packaging1		<i>18-7-20</i>
140	QC	1 pcs		5/21/18	0.00	0.00	QC3		<i>18-7-20</i>
150	HandFinish	1 pcs		5/21/18	0.00	0.50	HandFinish4		<i>18-7-21</i>
160	QC	1 pcs		5/21/18	0.00	0.00	QC5		<i>18-8-28</i>
170	Packaging	1 pcs		5/21/18	0.00	0.00	Packaging3-2		<i>DAS</i>
180	QC21-SA	1 Ea		5/21/18	0.00	0.00	QC21		<i>21 AUG 28 2018</i>

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M138834 START: 1:05.
OD.T. 375°.
FINISH: 1:00.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5061216
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5061862
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5058747
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5061952
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5066274
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5066247
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5068233
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5069386 x2
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5074862
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5058574
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5067578
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5058263
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5068716
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5076135
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5076130
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5054936
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5060244
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5078251
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5076007-1
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5078257
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5071415
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5067457

M.U.003681

004552

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	66	0
	D3913-1	1	13	0
	D3913-15	1	16	0
	D3913-3	1	15	0
	D3913-7	2	13	0
	D3913-9	1	7	0
	D3916-041	2	18	0
	D3916-5	3	11	0
	D4016-1	3	40	0
	D4017-7	3	51	0
	D4017-9	2	14	0
	D4020-11	2	25	0
	D4021-1	3	36	0
	D4034-041	1	6	0
	D4034-043	1	6	0
	D4672-1	2	46	0
	M304EX0.75-16F	33	1,055	0
	AN3-10A	6	225	0
	D2931	2	1,072	0
	D4021-5	2	26	0
150-HandFinish	MS20600-AD4W3	2	459	0
	MS21042L3	6	2,519	0
	NAS1149F0332P	12	2,454	0

Part Specifications

Specifications could not be found.



Container No: S078412



Part: D3913-041

Job No: 176464

Serial No/Batch: S078412

Revision:

Inspector:

Exp Date: 06/06/2018

Instructions:

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CANADA

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